

Date: Tuesday, 05/05/2009 12:56:11 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COVER
Job Number : 47736	
Estimate Number : 13918	
P.O. Number :	Part Number : D39393
This Issue : 05/05/2009 S.O. No. :	Drawing Number : D3939 PREL
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : PREL
Previous Run :	Material :
Written By :	Due Date : 12/05/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 09.05.05</u>	
Comment : Est Rev:A 09.05.04 new issue EC verified by:DD	

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
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Comment: Qty.: 0.0656 sf(s)/Unit Total : 0.3938 sf(s)
 6061-T6 .050 Sheet
 batch: 110791 B 9-5-5

Mat'l Cont'd

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3939
 Dwg Rev: PRE
 Prog Rev: Lm 1B9-5-5
 2-Deburr if necessary 1B 9-5-5

(9)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B9-5-5 (9)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

2905-08 (9)

ENGINEERING
APPROVAL

18/05/14

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

H1 09-05-08

(X9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 05/05/2009 12:56:11 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 47736

Part Number: D39393

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



⑨

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-05-8

7.0

PACKAGING 1

PACKAGING RESOURCE #1



⑨

Comment: PACKAGING RESOURCE #1

Identify with Dart part # using yellow paint marker and Stock

Location: _____

1

SENT TO H. SIEMANS
@ EAGLE

9/5/8

SE

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-08

E RECALL

09/05/14

AUTH

DATE

09/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

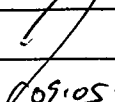
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47736
Description: COVER		Part Number: D3439-3
Inspection Dwg: D3439-3 Rev: PREL		Page 1 of 1

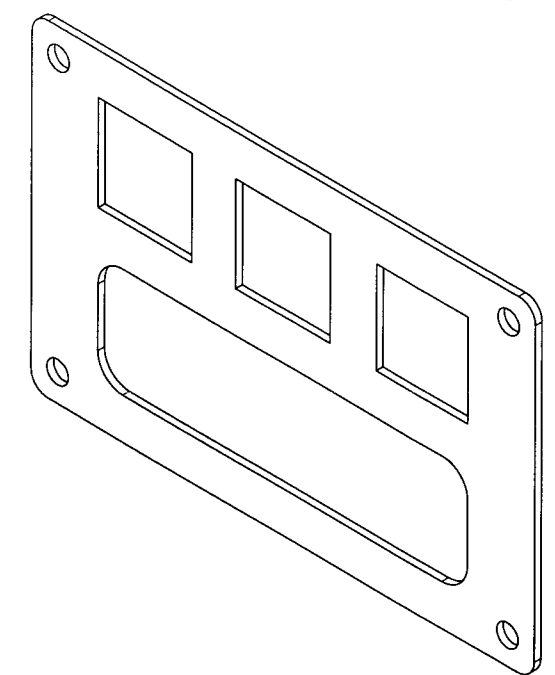
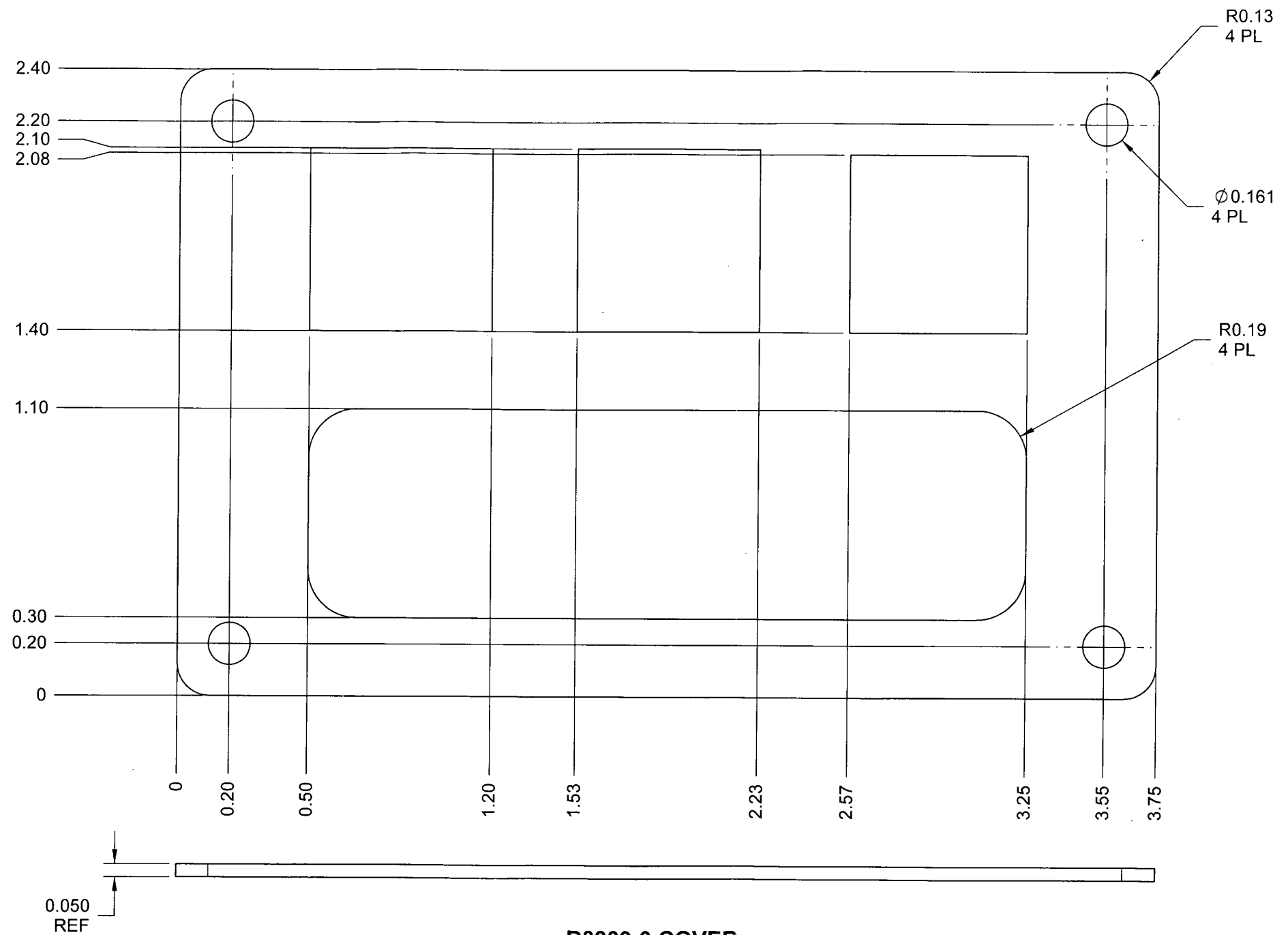
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .161	±.006-.001	.162	✓			
.20	±.030	.200	✗			
.50	±.030	.502	✗			
1.20	±.030	1.204	✗			
1.53	±.030	1.526	✗			
2.23	±.030	2.234	✗			
2.57	±.030	2.571	✗			
3.25	±.030	3.252	✗			
3.55	±.030	3.553	✗			
3.75	±.030	3.755	✗			
.20	±.030	.200	✗			
.30	±.030	.302	✗			
1.10	±.030	1.106	✗			
1.40	±.030	1.407	✗			
2.08	±.030	2.083	✗			
2.10	±.030	2.107	✗			
2.20	±.030	2.201	✓			
2.40	±.030	2.404	✗			
.050	±.010	.048	✗			

Measured by: IB	Audited by: 	Prototype Approval:
Date: 9-5-5	Date: 10/10/08	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47730

PRELIMINARY ISSUE
09/05/04 MJS

D3939-3 COVER

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3939-3" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3939	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

C

B

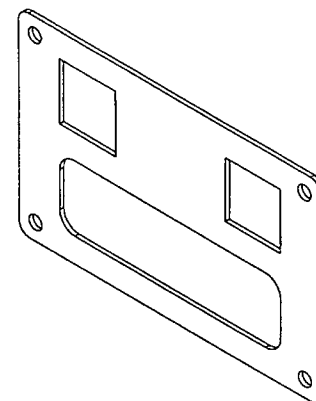
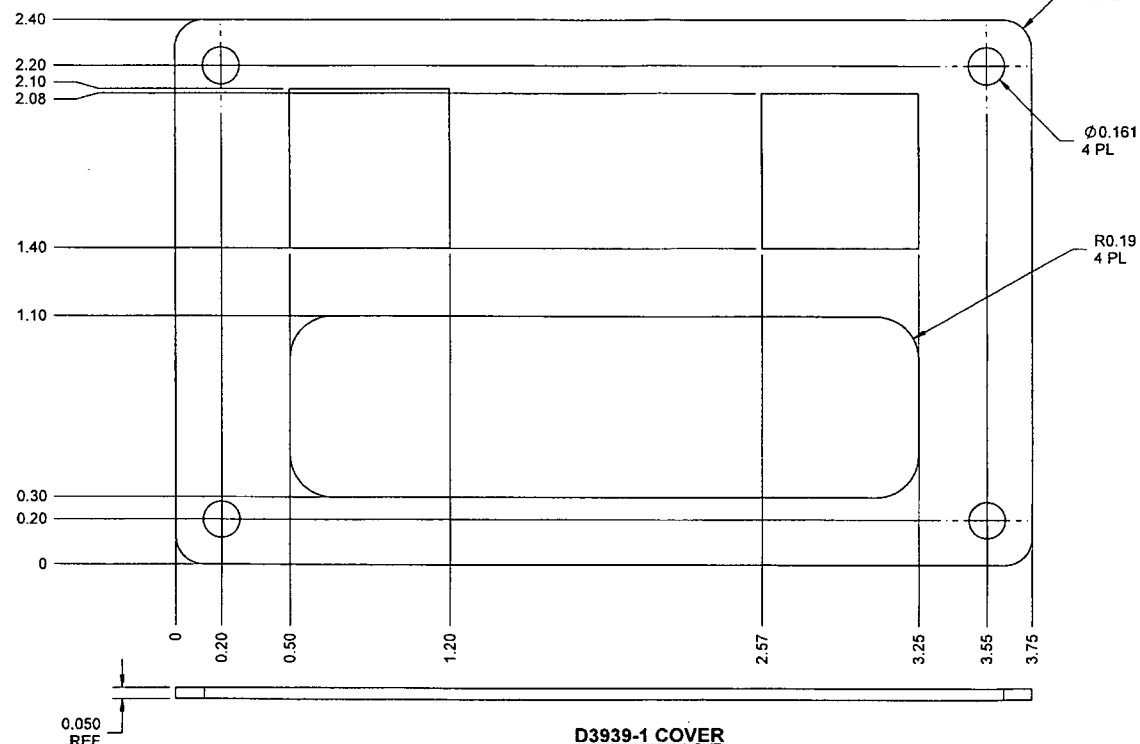
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RELEASED
-05-14-2009

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3939-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

47736

A		NEW ISSUE				09.05.01			
REV.		DESCRIPTION				BY		DATE	
DESIGN				DART AEROSPACE LTD					
DRAWN				HAWKESBURY, ONTARIO, CANADA					
CHECKED				DRAWING NO.				REV.	
MFG. APPR.		N/A		D3939				SHEET 1 OF	
APPROVED		(S)		TITLE				SCALE	
DE APPR.		N/A		COVER				NT	
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